

slip July 20th

Dart Aerospace Ltd.

Date: Monday, 7/10/2006 10:09:13 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT RH (FOLDING)		
Job Number	: 27848		Part Number	: D2801042		
Estimate Number	: 11653		Drawing Number	: D2801 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/10/2006		Drawing Revision	: A		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/28/2006		
Previous Run	: N/A		Qty:	1	Um:	Each
Written By	: <i>Sign comment below</i>					
Checked & Approved By	: <i>W.H. 06.07.10</i>					
Comment	Est	B01.04.26	Changed D2802-042 to -2 EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :									
1.0	D2622120C	Extrusion									
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)</p> <table><thead><tr><th>Qty</th><th>Part #</th><th>Description</th><th>Batch:</th></tr></thead><tbody><tr><td>1</td><td>D2622-120C</td><td>Extrusion</td><td><i>327077</i></td></tr></tbody></table> <p><i>Training</i> <i>FF 06.07.10</i> <i>J.E. 06.07.10</i></p>				Qty	Part #	Description	Batch:	1	D2622-120C	Extrusion	<i>327077</i>
Qty	Part #	Description	Batch:								
1	D2622-120C	Extrusion	<i>327077</i>								
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1									
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p>1-Cut D2622 extrusion to 86.15" long as per Dwg D2801</p> <p>2-Deburr and bevel ends for welding</p> <p><i>Training FF 06.07.10</i> <i>J.E. 06.07.10</i></p>											
3.0	QC5	INSPECT WORK TO CURRENT STEP									
<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p><i>FF 06-07-10</i></p>											
4.0	D2734	206 Step Endplate									
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)</p> <p>Pick:</p> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D2734</td><td>End Cap</td><td><i>324402</i></td></tr></tbody></table>				Qty	Part Number	Description	Batch	2	D2734	End Cap	<i>324402</i>
Qty	Part Number	Description	Batch								
2	D2734	End Cap	<i>324402</i>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 27848

Part Number: D2801042

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D28022

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2802-2	Arm	325709

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms as per Dwg D2801

Weld end caps as per Dwg D2801

Inspect for foreign object per QSI 024

Grind end cap welds flush

*LL 06-07-11
PE 06-07-11
PE 06-07-11
FF 06-07-12*

7.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-07-12

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PE 06-07-12

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

AM 06-07-12

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

FF 06-07-13

11.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Wing Walk per Dwg D2801 and QSI 005 4.4

SC 06/07/19 DL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-13		weld aft. end cap as per drawing	1/2	06-07-13	1	✓	✓
06-07-13		grind end cap flush	1/2	06-07-13	1	✓	✓
06-07-13		weld inspection	ERD	06-07-14	1		✓ 07-17
		touch up Hodge on end caps	SAD	06-07-14	1		
			SAD	06-07-14	1	✓	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/07/24.

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT RH (FOLDING)

Job Number: 27848

Part Number: D2801042

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0

QCF

INSPECT WORK TO CURRENT STEP



SK
06/07/19



EPD 06.07.14 (1)

PO

Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SK 06/07/19 (1)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SK 06.07.20

Job Completion



SK 06.07.19

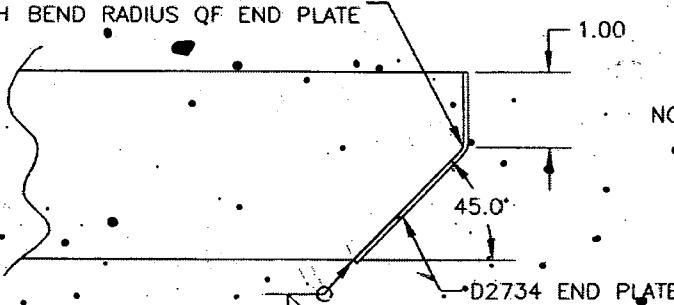
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06.07.20	12	QC 3 Si wing walk inspection. Perm. Change					<i>Z</i> CG 07.20

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

86.15
MEASURED BEFORE END CAPS WELDED IN PLACE

7.13
(REF)
7.50
(REF)

D2802-041 ARM
(2 PLACES)
USE D2802-042
FOR D2801-042
RH STEP ASS'Y

POCKET SIDE
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

REFER TO STEP
END DETAIL

D2801-1
MAKE FROM EXTRUSION D2622

D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DART

3 COPY
1000
0000

DESIGN	DRAWN BY	DART AEROSPACE LTD	
DATE	APPROVED	HAWKESBURY, ONTARIO, CANADA	
00.11.03	00.11.03	NEW ISSUE	REV. A
A	CP	D2801	SHEET 1 OF 1

RELEASED
00.11.13

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27848

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2000 by DART AEROSPACE LTD

